

SHIP FEB.

Work Order ID 156121

156121

Page 1

Thursday, January 26, 2017 11:10:57 AM

Item ID: D3875-1L08 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Floor Protector - Passenger Clear
 Start Date: 2/2/2017 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 2/7/2017 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan:  Date: JAN 26 2017 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3875	C

100		0.00							DAS 07 9-89
100									
HandThermo	Memo	0.06							17/01/31
Hand Finishing Thermoforming	1-Cut Sheet to required Blank size								

105		0.00							DAS 07 9-89
105	Dry Material								
HandThermo	Memo	0.00							17/01/31
Hand Finishing Thermoforming	Dry Sheet as per OSI022 POLYCARBONATE								
	Temp: 245 deg. F								
	Time IN: 5:00 PM								
	6:00 AM								
	Time OUT:								

JAN 30 2017

Per.....

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

156121

Thursday, January 26, 2017 11:10:57 AM

N900040100

Setup Start *NS1*

Stop *NS2*

6

Start Date: 2/2/2017 **Start Qty:** 6.00

Required Date: 2/7/2017 **Req'd Qty:** 6.00

6

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Insp.
Stamp

110

0.22

Thermoform

Thermoforming Machine

Memo

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA0xxusing tool DT9435
Dwg Rev: C
Folio Rev: C

Visually inspect for proper formation and texture

07
9-89

17/01/3

0.00

140

0.37

HandThermo

Hand Finishing Thermoforming

Memo

1-Trim to finished dimensions as per Dwg

DAS
07
9-89

17/02/01

QC2- Inspect parts off machine FAI/FAIB

0.00

150

0.01

QC

Quality Control

Memo

Complete FAI document

DAS
07
9-89

17/02/0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								

Work Order ID 156121***156121***

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Thursday, January 26, 2017 11:10:57 AM

Item ID: D3875-1L08

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Floor Protector - Passenger Clear

Start Date: 2/2/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 2/7/2017 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.02

Quality Control

DAS
38
9-89
FEB 01 2017

170

Identify as per dwg & Stock Location: St

0.00

170

Packaging

Memo

0.01

Packaging

6

DAS
6
9-89

FEB 06 2017

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.10

Quality Control

DAS
21
9-89

FEB 06 2017

DAS
21
9-89

FEB 06 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Thursday, January 26, 2017 11:11:01 AM

Page 1

Work Order ID: 156121

156121

Parent Item: D3875-1L08

D3875-1L08

Parent Item Name: Floor Protector - Passenger Clear

Start Date: 2/2/2017

Required Date: 2/7/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: Ipp Rev. C Added Color to D3875-1 14/07/02 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	791.1556	9.84	62.14737			DAS 07 9-89

MI FXS 118-90318-08

Lexan Sheet (Clear)

Location

Loc Qty

Loc Code

therm

791.15564

m126994

791.15564

62.1558 ft.

17/01/31

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order: 156120
Description: Floor Protector		Part Number: D3875-1
Inspection Dwg: D3875	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

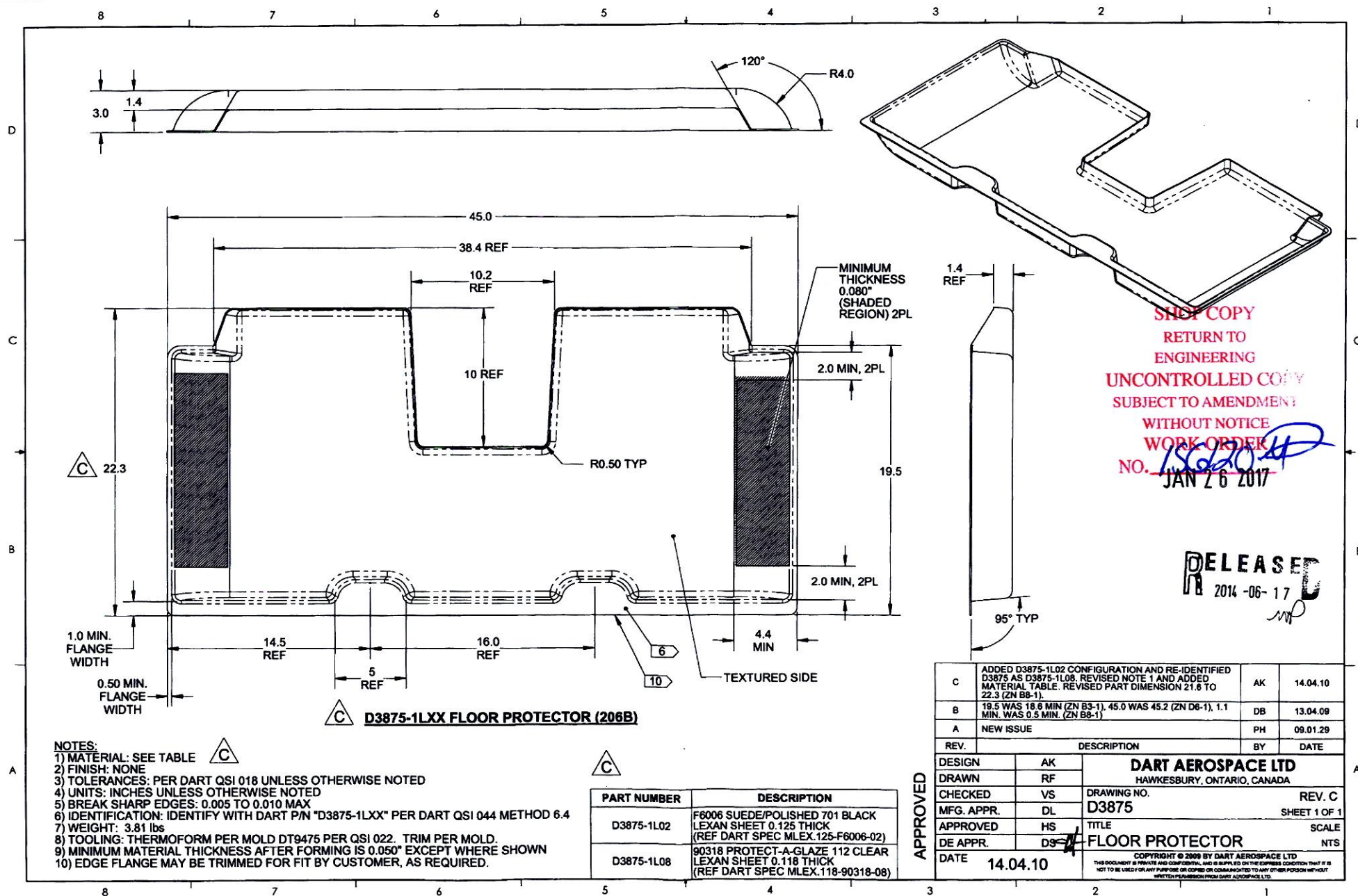
Measured by: <u>DAS 07 9-89</u>	Date: 17/01/31
--	-----------------------

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.061"	✓			
0.080	Min	0.090"	✓			
45.0	+/-0.100	45.0"	✓			
22.3	+/-0.100	22.3"	✓			
1.4	+/-0.100	1.42"	✓			

Measured by: <u>DAS 07 9-89</u>	Date: 17/02/01
Audited by: <u>38 FEB 01 2017 9-89</u>	Date: FEB 01 2017
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	
B	13.05.08	Dimensions updated per Dwg Rev B	KJ	
C	14.03.31	Dimension revised	KJ	
D	16.03.17	Dimensions updated per Dwg Rev C	KJ	



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 15620-4
 JAN 7 6 2017

RELEASE
2014-06-17

C	ADDED D3875-1L02 CONFIGURATION AND RE-IDENTIFIED D3875 AS D3875-1L08. REVISION NOTE 1 AND ADDED MATERIAL TABLE. REVISED PART DIMENSION 21.6 TO 22.3 (ZN BB-1).		AK	14.04.10
B	19.5 WAS 18.6 MIN (ZN B3-1), 45.0 WAS 45.2 (ZN D6-1), 1.1 MIN. WAS 0.5 MIN (ZN B8-1)		DB	13.04.09
A	NEW ISSUE		PH	09.01.29
REV.		DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3875 TITLE FLOOR PROTECTOR		
DRAWN	RF			
CHECKED	VS			REV. 1 OF
MFG. APPR.	DL			SHEET 1 OF
APPROVED	HS			SCALE
DE APPR.	D3875			NT
DATE	14.04.10		COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED OR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	